

"WESTERN FILES."

The Western File Co., "Limited," guarantees to furnish files, all kinds, and for all purposes, the most superior for both fast filing and durability to any ever made. This is a strong assertion, but it is a fact, and why? The pitch or inclination to the file, at which the chisel is held, the angles at which it is ground and whet, the free action of the chisel when the force is applied to it, all combine to make a perfect file. What the hand cutters call the "turn of the wrist," is simply allowing the chisel, when the blow is given, to freely follow the course to which the inclination at which it is set and the angles of its cutting faces draw it. That is, the chisel must be set at an angle varying from fifteen to thirty degrees from a perpendicular; if not held rigid, will change its course as soon as it enters the metal and will draw under to the bottom of the tooth, making, by its free action in entering the metal and drawing under, a sharper, smoother and deeper tooth; this, we are sure, will be apparent to any mechanic who has used a cold chisel.

It is alone for this enterprising Company to say that, with a daily capacity of over 1,000 dozen files, the largest in the world, they combine in their now perfect machinery, in which is used a Loose Chisel, not in any way fast in or to the hammer, and with as free action as if held with the hand, all the advantages of the hand-cut file, with the uniform force and accuracy of mechanical power applied to it. That is, by a patent appliance and automatic motion, the chisel is held at an exact and correct inclination for each kind of file, and when the blow is given, can freely follow the course to which the angles of its cutting faces draw it, and instantly adjusts itself as soon as the hammer is raised.

The correct inclination of the chisel is impossible for the most experienced workman by hand to always attain after each blow, and, in consequence, some of the teeth in a hand-cut file are hooking and liable to pin, and others stand back too much and will not cut.

With the use of the Loose Chisel, which allows the operator to make any shaped tooth desired, we are enabled to furnish files specially adapted to different kinds of work—for machine filing, for planer knives and the hardest steel worked, for cast iron and other rough usage, and guarantee them superior to ordinary files for such work.

These improvements were commenced in 1879 and completed in 1880, and we say to all consumers: Try these files, made by this New and Improved Method. We fully guarantee them to cut Easier, file Smoother and do more work than the best English Files.

L. M. RUMSEY MFG. CO.,

WESTERN FILE CO., LIMITED,
BEAVER FALLS, PA.

For Price List, see page 344.

WESTERN FILES.

(Adopted July 1st, 1881, by all Manufacturers.)

MILL SAW, ROUND AND SQUARE.				MILL.	FLAT AND WARDING.				HAND, HALF ROUND, PILLAR AND THREE SQUARE.			
Inch.	Bastard.	2d Cut.	Smooth.	Bastard One Round Edge.	Inch.	Bastard.	2d Cut.	Smooth.	Inch.	Bastard.	2d Cut.	Smooth.
To 4	1 40	1 65	1 75	1 50	To 4	1 50	1 75	1 90	4	1 60	1 85	2 00
5	1 60	1 85	2 06	1 72	5	1 70	2 00	2 15	5	1 85	2 10	2 35
6	1 85	2 10	2 35	2 00	6	2 00	2 35	2 55	6	2 20	2 55	2 80
7	2 20	2 55	2 80	2 35	7	2 40	2 80	3 05	7	2 65	3 05	3 30
8	2 65	3 05	3 30	2 85	8	2 90	3 35	3 65	8	3 15	3 65	3 95
9	3 15	3 65	3 95	3 38	9	3 50	4 00	4 35	9	3 80	4 35	4 75
10	3 80	4 35	4 75	4 08	10	4 15	4 75	5 20	10	4 50	5 20	5 60
11	4 50	5 20	5 60	4 85	11	4 80	5 60	6 05	11	5 25	6 05	6 60
12	5 35	6 15	6 70	5 75	12	5 80	6 65	7 25	12	6 25	7 20	7 80
13	6 40	7 35	8 00	6 88	13	6 85	7 90	8 55	13	7 35	8 50	9 20
14	7 65	8 75	9 55	8 22	14	8 15	9 40	10 20	14	8 75	10 10	10 95
15	9 10	10 50	11 40	9 78	15	9 75	11 20	12 20	15	10 35	11 90	12 95
16	10 80	12 40	13 50	11 61	16	11 55	13 30	14 45	16	12 25	14 10	15 35
17	12 60	14 55	15 75	13 54	17	13 60	15 65	17 00	17	14 55	16 75	18 20
18	14 70	16 90	18 40	15 80	18	16 00	18 45	20 00	18	17 25	19 90	21 60
19	17 10	19 70	21 35	18 38	19	18 75	21 55	23 40	19	20 30	23 40	25 40
20	19 70	22 70	24 65	21 18	20	21 80	25 10	27 30	20	23 90	27 50	29 90

EXTRAS.
Mill Double Cut and Mill Pointing.
Advance 1 Inch.

EXTRAS.
Cants (Double).
Advance 2 Inches.
Feather Edge (Double).
Advance 3 Inches.

EXTRAS.
Knife and High Back Half Round.
Advance 1 Inch.
Cross and Slotting.
Advance 2 Inches.

SAW FILES.

WOOD FILES AND RASPS.

Inch.	Taper, Single Cut.	Taper, D'be Cut to Point.	Slim Taper Single Cut.	Slim Taper Double Cut to Point.	Inch.	Pit Saw Blunt Single Cut.	Band Saw Taper Single Cut.	Gin Saw Taper Single Cut.	Inch.	Cabinet File and Rasp.	Half Round Wood Rasp.	Flat Wood Rasp.
3	1 05	1 35	1 15	1 45	3	1 50	1 70	1 60	6	2 90	2 55	2 35
3½	1 05	1 35	1 15	1 45	3½	1 50	1 70	1 60	7	3 50	3 05	2 80
4	1 20	1 50	1 25	1 55	4	1 60	1 85	1 75	8	4 20	3 65	3 35
4½	1 35	1 75	1 40	1 75	4½	1 70	2 05	1 95	9	5 00	4 35	4 00
5	1 60	2 00	1 55	1 95	5	1 85	2 35	2 10	10	6 00	5 20	4 75
5½	1 85	2 35	1 75	2 20	5½	2 10	2 65	2 30	11	7 00	6 05	5 60
6	2 15	2 75	2 05	2 55	6	2 45	3 00	2 45	12	8 25	7 20	6 65
7	2 75	3 45	2 45	3 10	7	3 15	3 70	2 80	13	9 65	8 50	7 90
8	3 45	4 30	3 00	3 75	8	3 95	4 50	3 15	14	11 30	10 10	9 40
9	4 30	5 40	3 65	4 55	9	4 80			15	13 15	11 90	11 20
10	5 35	6 70	4 50	5 60	10	5 80			16	15 40	14 10	13 30
11	6 60	8 25	5 55	6 90	11	6 85						
12	8 00	10 00	6 85	8 55	12	8 00						
13	9 55	11 95	8 40	10 50	13							
14	11 30	14 15	10 35	12 90	14							

EXTRAS.
Taper Single Cut to Point.
Advance 1 Inch.

EXTRAS.
Round Gulleting takes Pit-Saw Price.

EXTRAS.
Half Round Wood Files.
Take 1-2 Round Bastard Price.
Flat Wood Files.
Take Flat Bastard Price.

SHOE RASPS.

HORSE RASPS.

Hook Tooth Blunt Single Cut.

Inch.	Half Round Rasps.	Flat Rasps.	Last Mkr's Rasp.	Oval Shoe Rasp.	Inch.	Plain Rasps.	Beveled Rasps.	Tang'd Rasps.	6	Inch.	2 65
6	2 45	2 00		3 15	10	4 65	5 35	6 30	7	"	3 15
7	2 65	2 40		3 40	11	5 35	6 30	7 55	8	"	3 80
8	3 10	2 90		3 95	12	6 30	7 55	9 00	9	"	4 50
9	3 75	3 50		4 75	13	7 55	9 00	10 80	10	"	5 25
10	4 60	4 10		5 80	14	9 00	10 80	12 80	11	"	6 15
11	5 70	4 85		7 10	15	10 80	12 80	15 00	12	"	7 10
12	7 00	5 80	9 00	8 70	16	12 80	15 00	17 60			
13			10 50		17	15 00	17 60				
14			12 10		18	17 60					

Round Off.
Takes Hook Tooth Price.

EXTRAS (GENERAL).

One Round Edge, advances 7½ per cent., and two round edges 15 per cent. on respective Kinds and Cuts.

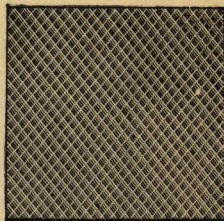
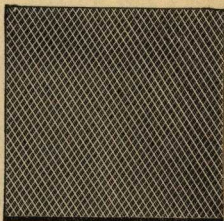
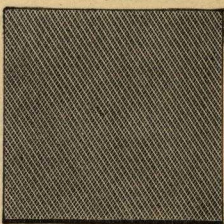
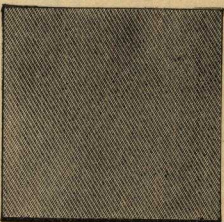
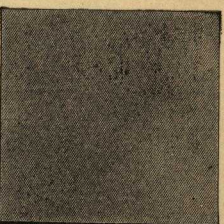
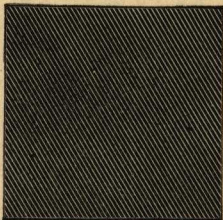
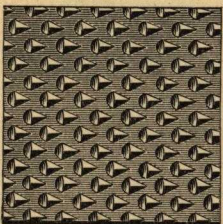
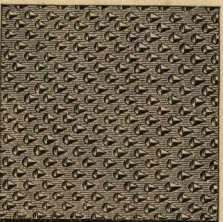
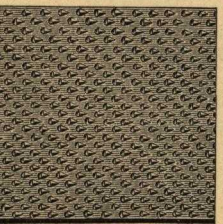
Dead Smooth double the price of Bastard Cut, Equalings (Bellied), advanced 2 inches on respective Kinds and Cuts.

Size, Below 4 inches, not extended, take price of 4 inch; ½ inches not specified take next higher full inch price.

All lengths above those listed, and Files varying from standard sizes, shall be classed as Irregular goods, and be subject to special prices.

Rough, coarse, or other than regular cuts (except those herein provided for), which are made upon Standard, Shaped Blanks, and also Blunt Files, advances one inch on respective kinds and Cuts.

CUTS OF FILES AND RASPS.

Rough.*Bastard.**2nd Cut.**Smooth.**Dead Smooth.**Mill Bastard.**Mill 2nd Cut.**Bastard. RASPS.**2nd Cut.**Smooth.*

GRADES OR CUTS OF LEADING REGULAR FILES.

In describing the various grades of cuts, we take as our standard a 12-inch file, using an inch section from the center of the file.

The grades are divided as follows:

ROUGH RASPS, SECOND CUT, SMOOTH AND DEAD SMOOTH.

These five grades are those most in use, and are made from or by two separate cuts on the file, which forms a diamond shaped tooth. The first cut which is put on the file is known as the "over cut," and the second as the "up cut." For "Mill Saw" and "Taper Saw" files only, the "over cut" is used to form the tooth, the tooth being a sharp ridge of metal extending at a sharp angle across the face of the file, and not intersected by any other stroke of the cutting chisel. This last tooth, as applied to Mills and Tapers, goes under the two grades of Bastard and Second Cut. The only other tooth which is in use, is that applied to Horse Rasps, Wood Rasps, Cabinet Rasps and Shoe Rasps. This tooth is based on a conical form by the use of a punch. On Horse Rasps it is too large to designate by any grade of cut. On Wood and Cabinet Rasps it is graded under the head of Bastard, Smooth, and sometimes Second Cut. As a matter of convenience, the grade of the tooth is given by counting only one of the cuts of the file, and we take for this the "over cut," or first cut.

The Wood Rasps and Cabinet Rasps having a punched or raised tooth (each tooth being separate from the other), we give the exact number to the square inch.

Rough is formed of twenty-two teeth to the running inch.

Bastard is formed of thirty-two teeth to the running inch.

Second Cut is formed of forty-four teeth to the running inch.

Smooth is formed of sixty-eight teeth to the running inch.

Dead Smooth is formed of one hundred and twenty to the running inch.

Mill Bastard is formed of a series of diagonal teeth, thirty-six to the inch.

Mill Second Cut is formed of a series of diagonal teeth, forty-four to the inch.

Taper Saw Single Cut, Second Cut, is formed of a series of diagonal teeth, fifty to the inch.

Wood Rasps have a punched tooth, known as bastard grade, one hundred and five teeth to the inch.

Cabinet Rasps have a punched tooth, known as second cut, one hundred and sixty-eight teeth to the inch.

Flat Bastard, 6 in.



Flat Second Cut, 6 in.



Hand Smooth, 6 in.



Hand Dead Smooth, 6 in.



Round Bastard, 6 in.



Half Round Bastard, 6 in.



Taper Saw File, 6 in.



Band Saw Taper File, 6 in.



Slim Taper Saw File, 6 in.



Mill Bastard, 6 in.



3 Square Bastard, 6 in.



Warding Bastard, 6 in.



Equaling Bastard, 6 in.**Pillar Bastard, 6 in.****Square Bastard, 6 in.****Crossing Bastard, 6 in.****Cabinet File, 6 in.****Half Round Wood Rasp, 6 in.****Cabinet Rasp, 6 in.**